

Slip 48/05

Date: Thursday, 5/10/2007 2:23:41 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 32269		
Estimate Number	: 12734		
P.O. Number	: N/A	Part Number	: D353525
This Issue	: 5/10/2007 S.O. No. : N/A	Drawing Number	: D3535 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: AB # 07-05-10
Previous Run	: N/A	Material	: N/A
Written By	:	Due Date	: 5/17/2007
Checked & Approved By	: [Signature] 07.05.10	Qty:	4 Um: Each
Comment	: Est Rev: A New Issue 07-02-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.5355 sf(s)/Unit Total : 2.1420 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: M101 873 (3) M103713 (4) SAD 07/05/14

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: B

Prog Rev: B

NOTE: CHECK Rev of DWG and Flat pattern

2-Deburr if necessary

SAD 07/05/14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/14

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07.05.15 (4)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT8326

2-Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25

mf 07-05-16
mf 07-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 12 Date: 07/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:23:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32269

Part Number: D353525

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/16 (4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

UJ 07-05-17 (4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EP 07/05/18 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/05/18 (4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

RA 07/05/18 (4)

Job Completion




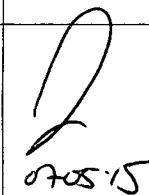


UJ 07.05.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/14	2.0	wrong Re Scrap one part wrong Revision	 R&S1042	Scrap - destroy replace	SAM 07/05/14	 R&S-15	 R&S1042	 070515

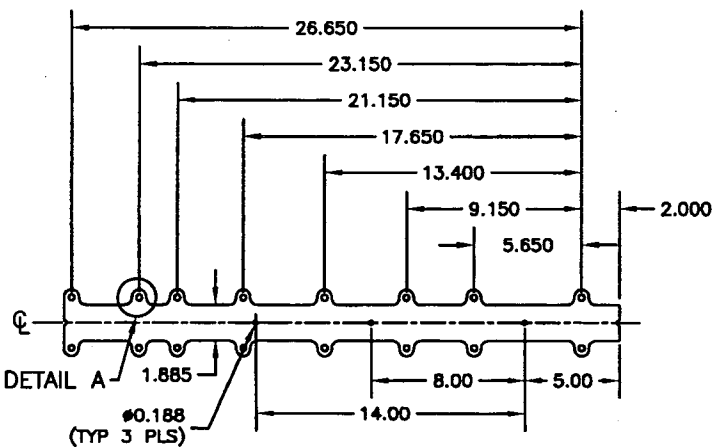
NOTE: Date & initial all entries

DART

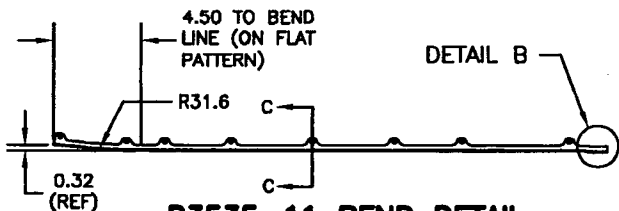
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07.04.24

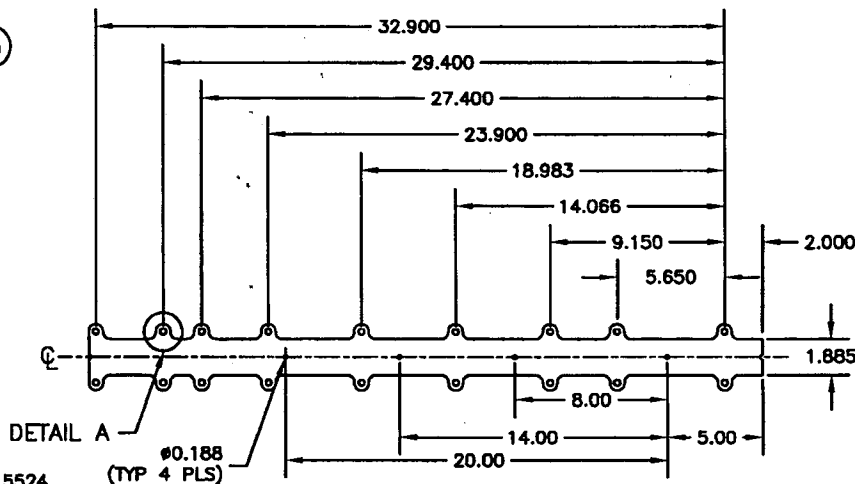
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CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB. OUTBOARD, ADD AMS SPEC		



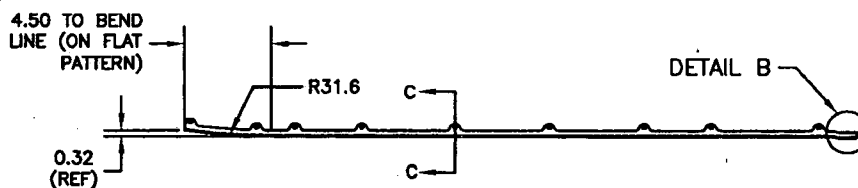
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

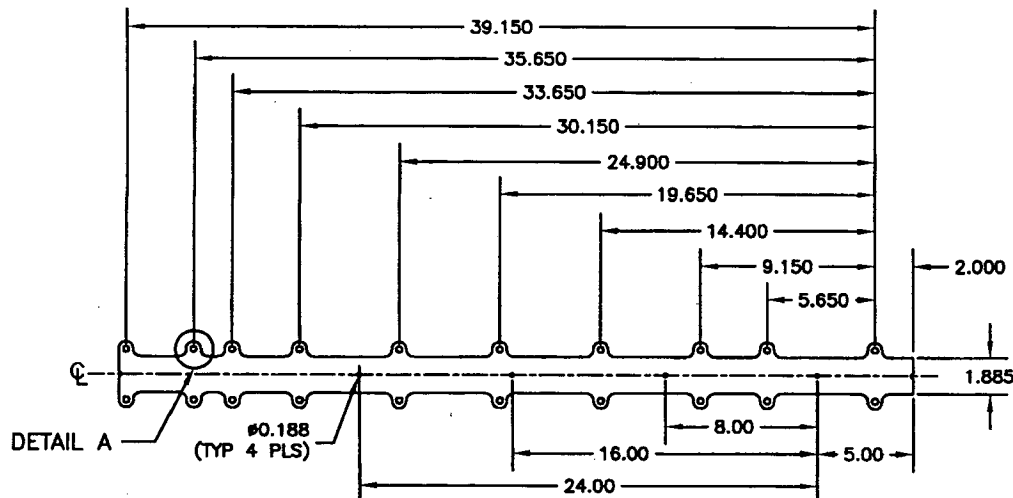
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WORK ORDER
NO. 32269

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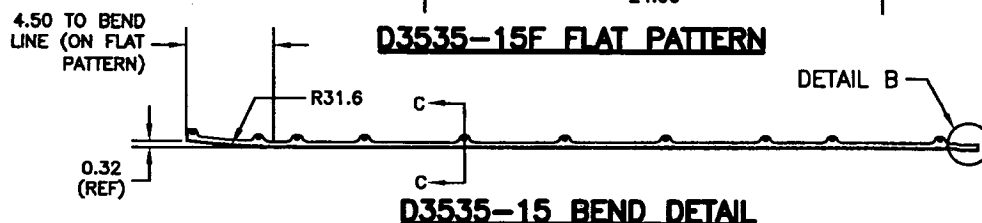
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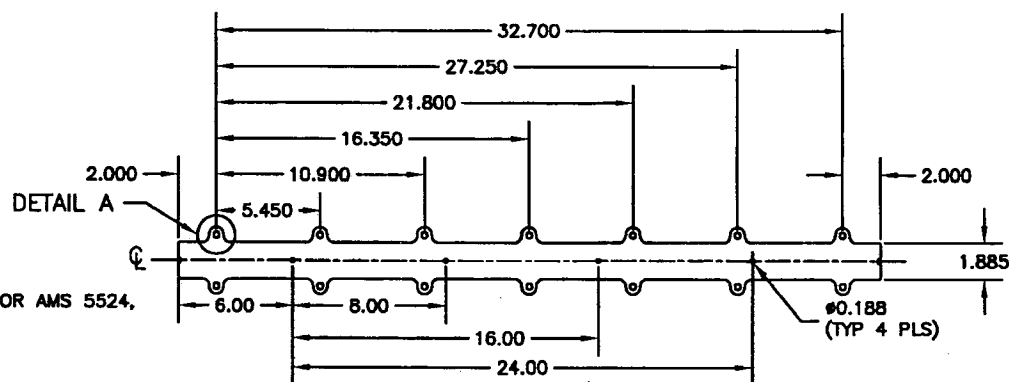
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 2 OF 7
		SCALE	1:10	



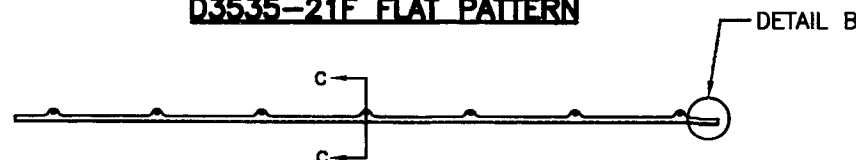
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

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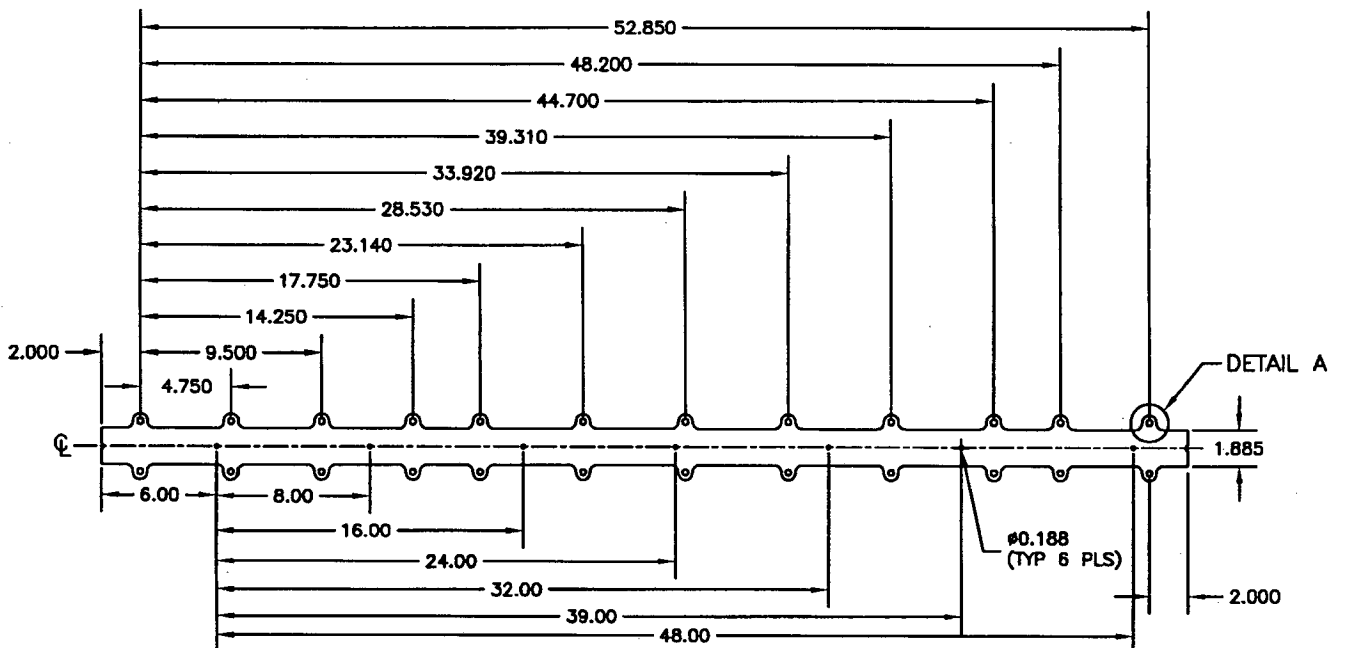
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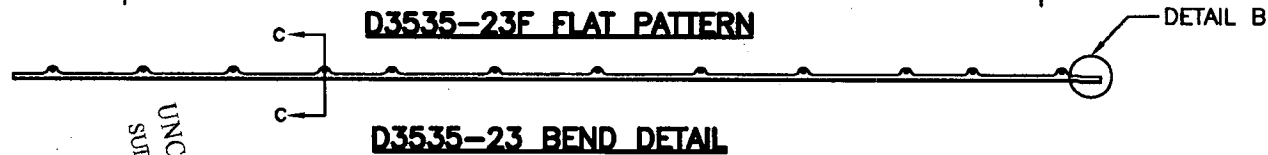
RELEASED

07.04.24

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CHECKED	#	APPROVED	#	PORT HADLOCK, WA
DATE	07.04.17	TITLE	WEARSHOE	REV. B
		DRAWING NO.	D3535	SHEET 3 OF 7
		SCALE	1:10	



D3535-23F FLAT PATTERN

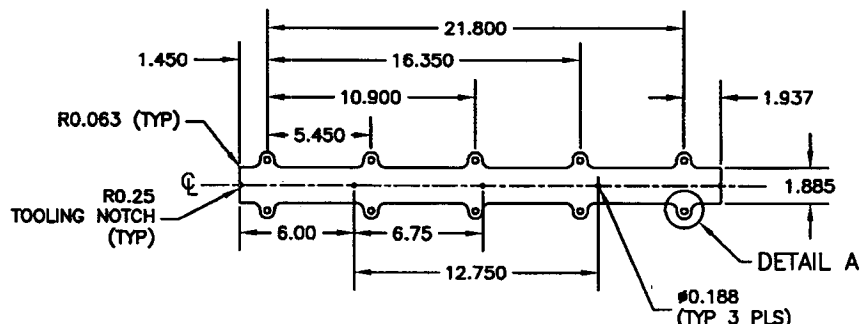


D3535-23 BEND DETAIL

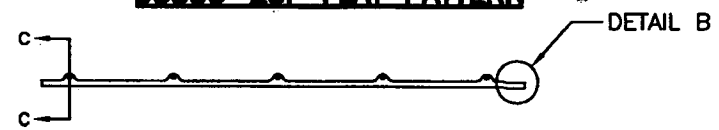
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WORK ORDER
NO. 32269

NOTES

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- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D3535-25F FLAT PATTERN

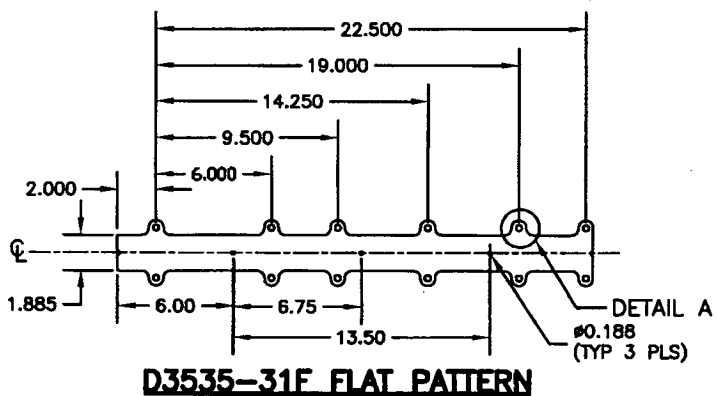
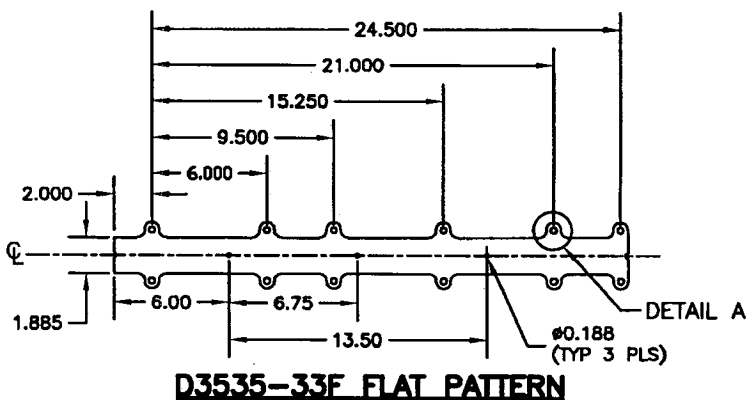


D3535-25 BEND DETAIL

DART

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07.04.24

**D3535-31 BEND DETAIL****D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL**

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NO. 32269

NOTES

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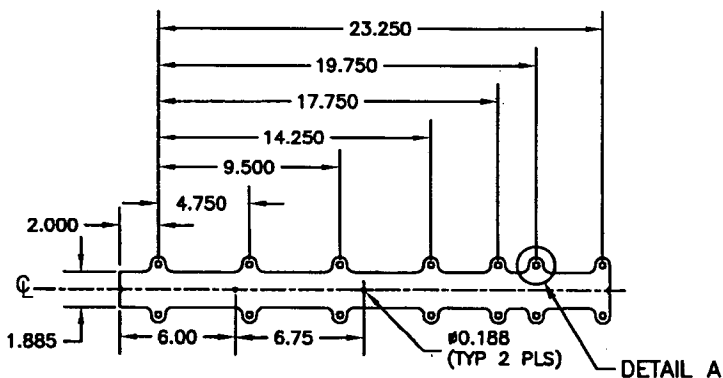
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
TITLE	WEARSHOE	SHEET	4 OF 7	SCALE
				1:10

DART

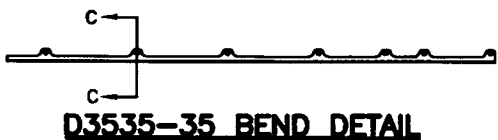
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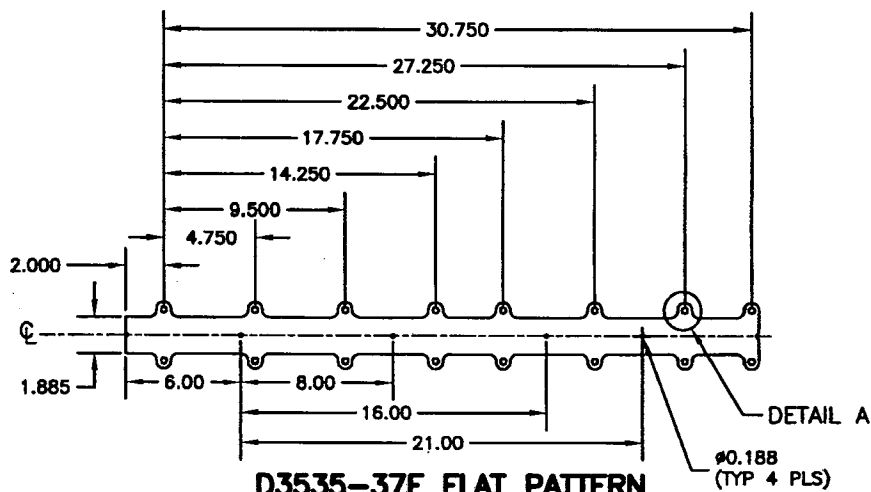
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
TITLE	WEARSHOE	SHEET	5 OF 7	SCALE
				1:10



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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NOTES

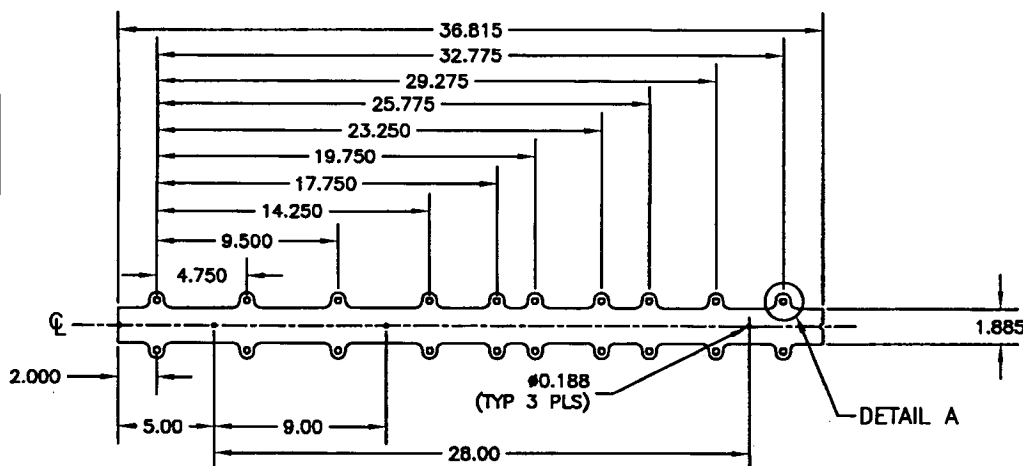
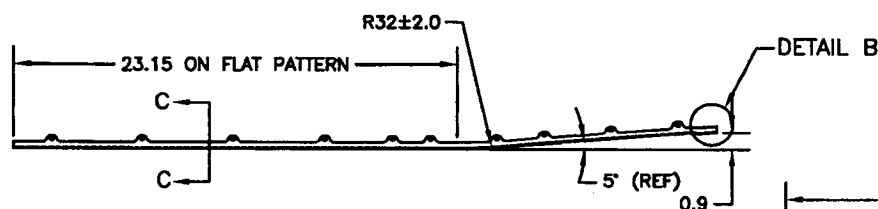
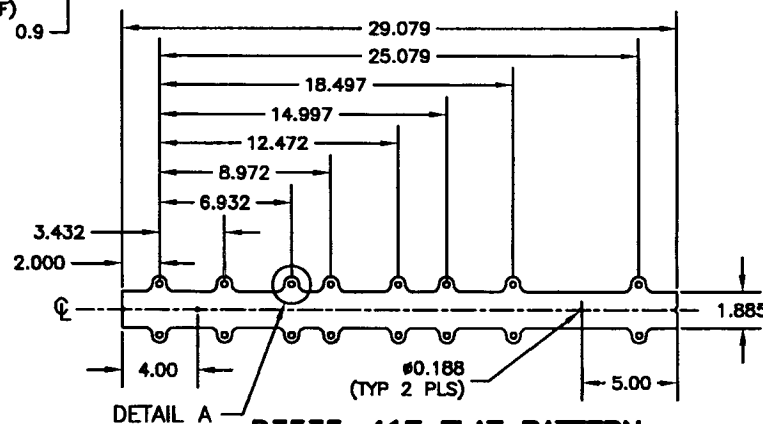
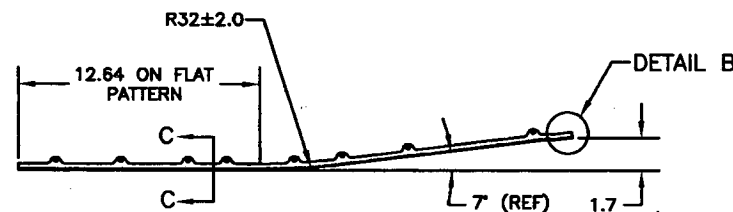
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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07.04.24

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C.B.	M	PORT HADLOCK, WA	
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		D3535	SHEET 6 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

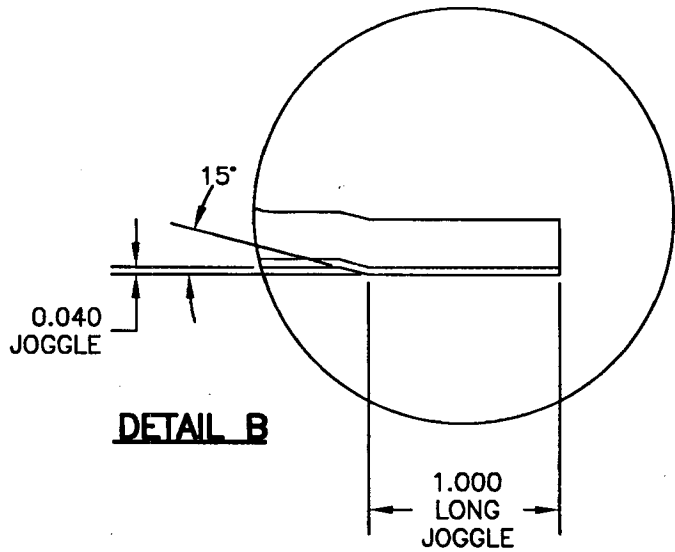
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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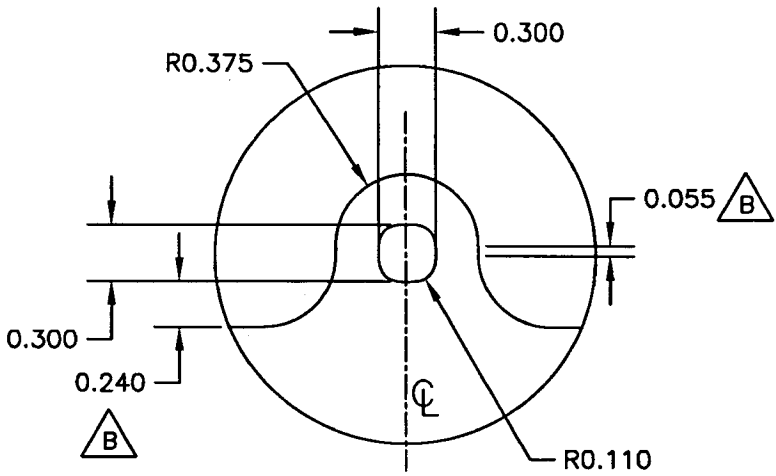


DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 7 OF 7
		SCALE	1:1	

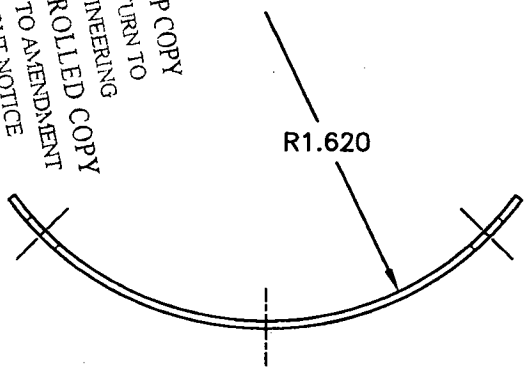
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07.04.24 *[Signature]*



DETAIL B



DETAIL A



SECTION C-C

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WITHOUT NOTICE
WORK ORDER
NO. 32269

DART AEROSPACE LTD		Work Order: 32269
Description: WEARSHOE		Part Number: D353525
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 21.800	+/- 0.010	21.800	✓		M-T/Vern	
B 16.350	+/- 0.010	16.350	✓		M-T/Vern	
C 10.900	+/- 0.010	10.900	✓		M-T/Vern	
D 5.450	+/- 0.010	5.488	✓		Vern	
E 1.450	+/- 0.010	1.458	✓		height-gauge	
F 6.00	+/- 0.030	6.01	✓		height-gauge	
G 6.75	+/- 0.030	6.744	✓		height-gauge	
H 12.750	+/- 0.010	12.750	✓		M-T	
I 1.885	+/- 0.010	1.892	✓		Vern	
J 1.937	+/- 0.010	1.937	✓		M-T/height-gauge	
K 0.300	+/- 0.010	0.302	✓		Vern	
L 0.300	+/- 0.010	0.302	✓		Vern	
M 0.038	+/- 0.010	0.037	✓		Vern	
N 0.188	+/- 0.005 0.003	0.191	✓		Vern	
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: [Signature]	Prototype Approval: N/A		
Date: 07/05/14	Date: 07/05/15	Date: N/A 07.05.14		
Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

